

Work Order ID 127312

December-17-14 1:12:48 PM

127312

Page 1

Item ID: 41232-200-001-002 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Actuator RH Assembly
 Start Date: 12/11/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-23 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
41232-200-001	Rev IR

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per Dwg 41232-200-001 2-Torque as per Dwg 41232-200-001								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	Identify as per dwg & Stock Location: <u>S+578</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

1 FF FEB 02 2015

(1) 38 9-89
 FEB 02 2015

1 MLS 15-02-04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127312

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Page 2

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Item ID: 41232-200-001-002 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Actuator RH Assembly
 Start Date: 12/11/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MLJ 15-02-04
ME
15-2-4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1

Work Order ID: 127312

127312

Parent Item: 41232-200-001-002

41232-200-001-002

Parent Item Name: Step Actuator RH Assembly

Start Date: 12/11/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-02-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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41232-200-002-001		Manufactured	No			100	Each	21.0000	1	1			
										**	<i>FF</i>	FEB 02 2015	

41232-200-002-001

Tube

Location	Loc Qty	Loc Code
ST579	21	
105453	6	
107897	15	

41232-200-002-003		Manufactured	No			100	Each	18.0000	1	1			
										**	<i>FF</i>	FEB 02 2015	

41232-200-002-003

Latch

Location	Loc Qty	Loc Code
ST579	18	
107899	6	
109905	10	
93722	2	

41232-200-002-005		Manufactured	No			100	Each	23.0000	1	1			
										**	<i>FF</i>	FEB 02 2015	

41232-200-002-005

Pivot Arm

Location	Loc Qty	Loc Code
ST579	23	
107747	3	
107898	10	
109906	10	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 127312

127312

Parent Item: 41232-200-001-002

41232-200-001-002

Parent Item Name: Step Actuator RH Assembly

Start Date: 12/11/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

41232-200-005-003

Manufactured

No

100

Each

7.0000

2

2

41232-200-005-003

Spacer (Step Actuator)

FF

FEB 02 2015

Location

Loc Qty

Loc Code

ST580

7

107901

6

30501

1

2

AN315-4R

Purchased

No

100

Each

133.0000

1

1

AN315-4R

Nut

FF

FEB 02 2015

Location

Loc Qty

Loc Code

ST331

133

M128978

133

1

AN3-22A

Purchased

No

100

Each

18.0000

1

1

AN3-22A

Bolt

FF

FEB 02 2015

Location

Loc Qty

Loc Code

ST348

18

110998

18

1

AN842-4D

Purchased

No

100

Each

12.0000

1

1

AN842-4D

Elbow

FF

FEB 02 2015

Location

Loc Qty

Loc Code

ST324

12

124858

2

M122170

6

M127290

4

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 127312

127312

Parent Item: 41232-200-001-002

41232-200-001-002

Parent Item Name: Step Actuator RH Assembly

Start Date: 12/11/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

D3975-042

Manufactured No

100 Each

12.0000

1

1

D3975-042

Gas Cylinder Assembly, RH

FF

FEB 02 2015

Location

Loc Qty

Loc Code

ST074

12

101883

4

61799

3

87191

5

MS16996-23

Purchased No

100 Each

376.0000

1

1

MS16996-23

cap screw

FF

FEB 02 2015

Location

Loc Qty

Loc Code

ST316

376

112492

376

MS20822-4

Purchased No

100 Each

8.0000

1

1

MS20822-4

elbow

FF

FEB 02 2015

Location

Loc Qty

Loc Code

ST306

8

m126275

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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127312

Parent Item: 41232-200-001-002

41232-200-001-002

Parent Item Name: Step Actuator RH Assembly

Start Date: 12/11/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

998.0000

1

1

MS21042L3

FF FEB 02 2015

Nut

Location

Loc Qty

Loc Code

FP001

131264

489

M130922

489

GA

33

M128754

33

ST305

473

M130799

473

ST307

3

123900

3

NAS1149D0363J

Purchased

No

100

Each

2,128.000

2

2

NAS1149D0363J

FF FEB 02 2015

Washer

Location

Loc Qty

Loc Code

CA

673

m130799

673

FP001

154

m126319

154

GA

810

m128429

810

ST269

491

122378

254

m126319

237

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:12:47 PM

Page 5

Work Order ID: 127312

127312

Parent Item: 41232-200-001-002

41232-200-001-002

Parent Item Name: Step Actuator RH Assembly

Start Date: 12/11/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

100

Each

6,559.000

2

2

NAS1149D0463.J

WASHER

FF FEB 02 2015

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1155

M129390

1155

ST269

4599

M129390

12

M130799

4587

2

S-1455

Purchased

No

100

Each

50.0000

1

1

S-1455

Spring-Step Actuator (Replaces 71459)

FF FEB 02 2015

Location

Loc Qty

Loc Code

ST561

50

110154

35

111342

15

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

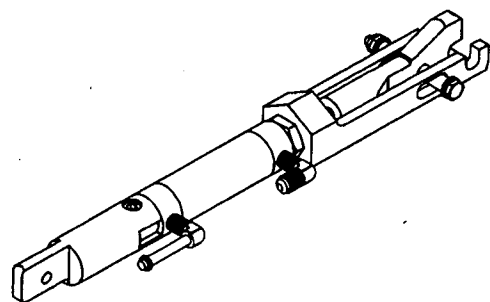
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

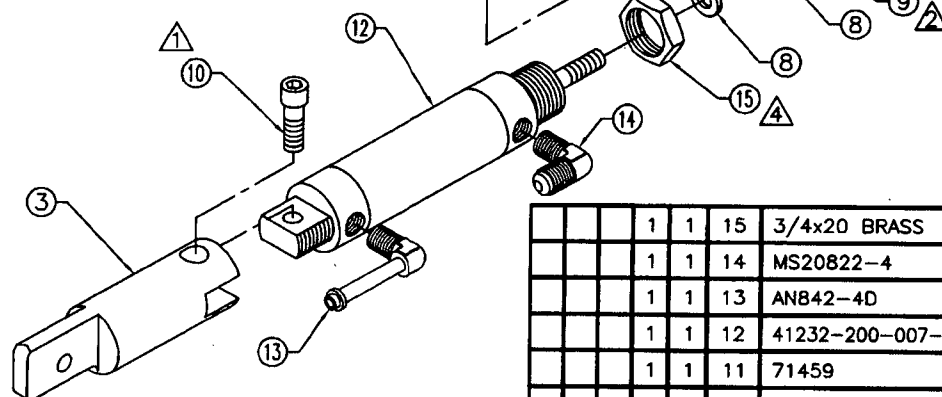
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

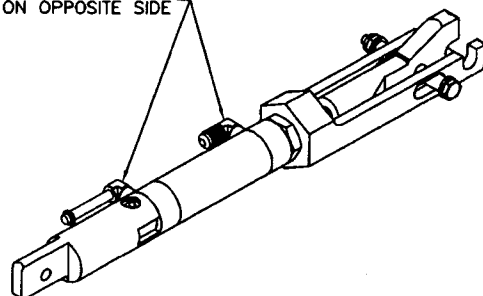
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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-001 L/H ACTUATOR ASSY



INSTALL ITEM #12
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASSY

- ⚠ TORQUE 80-100 IN.-LB.
- ⚠ TORQUE 20-25 IN.-LB.
- ⚠ TORQUE 50-75 IN.-LB.
- ⚠ TORQUE 50-75 IN.-LB.

NOTES:

12312 MLJ
14-12-23

NO.	REQ'D	PER	ASSY	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE
1	1	15		3/4x20 BRASS	CYLINDER NUT				
1	1	14		MS20822-4	ELBOW				
1	1	13		AN842-4D	ELBOW				
1	1	12		41232-200-007-001	CYLINDER				
1	1	11		71459	SPRING				
1	1	10		MS16996-23	CAP SCREW				
1	1	9		AN315-4R	NUT				
2	2	8		AN960JD416	WASHER				
2	2	7		AN960JD10	WASHER				
1	1	6		MS21042-L3	NUT				
1	1	5		AN3-22A	BOLT				
2	2	4		41232-200-005-003	SPACER				
1	1	3		41232-200-002-005	PIVOT ARM				
1	1	2		41232-200-002-003	LATCH				
1	1	1		41232-200-002-001	TUBE				
				-002	R/H ACTUATOR ASSY				
				-001	L/H ACTUATOR ASSY				
				-002-001	FND NO.				

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						DWG. SIZE C		SCALE NONE		Era Aviation, Inc.	